



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4293-1
Job Sheet 170389



Part No: D4293-1

Job Qty: 4 ea

Part Name: Fitting



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/16/18

Job Tracking No:

Due Date: 2/16/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV C IPP REV:A NEW ISSUE 10-11-15 JLM VERIFIED BY:DD IPP REV B: AS PER REV B 11-02-15
JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	2/15/18	2/15/18	0.00	0.00	Start Up Machining-2		SS
100	Bandsaw	4 pcs	2/15/18	2/15/18	0.00	0.40	Bandsaw1		SS
110	CNC Vertical Machining	4 pcs	2/15/18	2/15/18	0.00	10.52	HAAS1-4		SS 18-03-06
120	QC	4 pcs	2/15/18	2/15/18	0.00	0.00	QC2 Machining-2		SS
130	QC	4 pcs	2/15/18	2/15/18	0.00	0.00	QC8 Machining-2		SS 18-03-07
140	HandFinish	4 pcs	2/15/18	2/15/18	0.00	0.43	HandFinish1		SA 18-03-07
150	Powdercoat	4 pcs	2/15/18	2/15/18	0.00	0.36	Powdercoat1		DAS
160	QC	4 pcs	2/15/18	2/15/18	0.00	0.00	QC3		38
170	Small Fab	4 pcs	2/16/18	2/16/18	0.00	0.25	Small Fab-6		SS 9-88 DAS
180	QC	4 pcs	2/16/18	2/16/18	0.00	0.00	QC5		38
190	Packaging	4 pcs	2/16/18	2/16/18	0.00	0.00	Packaging3-2		SS 9-88 DAS
200	QC21-SA	4 Ea	2/16/18	2/16/18	0.00	0.00	QC21		SS 6

Part Op 100 - Cut Blank to 6.800" Batch: *****

Descriptions: 110 - 1-Machine per folio FB005 DWG REV: ***** FOLIO REV: ***** 21 MAR 15 2018 9-82- Debur and break all sharp edges

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

140 - Chemical Conversion Coat per QSI005 4.1

150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum MASK THREADED HOLE

160 - QC3- Inspect Part Finish

170 - INSTAL HELICOIL AS PER DWG

180 - QC5- Inspect part completeness to step on W/O

190 - Identify as per dwg & Stock Location: *****

200 - QC21- Final Inspection - Work Order Release

S047870

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M7075T73B4.000x4.000	2	3	0	0
170-Small Fab	MS21209F1-10	4	13	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scr ☐ Use-as ☐ Suspected Unapprove ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Prod Eng. Coord. ☐ Quality ☐ Packaging ☐ Other ☐ Supplier ☐																																																																																										
Date : _____		Step #: _____		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																																																										
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<table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th colspan="4" style="text-align: left;">Root Cause</th> </tr> </thead> <tbody> <tr> <td style="width:15%;">Environment</td> <td style="width:5%;">☐</td> <td style="width:15%;">No Re-verification</td> <td style="width:15%;">☐</td> <td style="width:15%;">Pressure/Forced</td> <td style="width:5%;">☐</td> <td style="width:15%;"></td> </tr> <tr> <td>Design</td> <td>☐</td> <td>Operator</td> <td>☐</td> <td>Bending</td> <td>☐</td> <td></td> </tr> <tr> <td>Doc/Data</td> <td>☐</td> <td>Offset/Setup</td> <td>☐</td> <td>Centre Not Concentric</td> <td>☐</td> <td></td> </tr> <tr> <td>Equip/Tooling</td> <td>☐</td> <td>Supplier</td> <td>☐</td> <td>Cracks</td> <td>☐</td> <td></td> </tr> <tr> <td>Handling/Pre</td> <td>☐</td> <td>Training</td> <td>☐</td> <td>Crimp/Kink/Ripple/Wave</td> <td>☐</td> <td></td> </tr> <tr> <td>Material</td> <td>☐</td> <td>Use for Testing</td> <td>☐</td> <td>Cuffs</td> <td>☐</td> <td></td> </tr> <tr> <td>Internal Transport</td> <td>☐</td> <td>Poor Information</td> <td>☐</td> <td>Crushing</td> <td>☐</td> <td></td> </tr> <tr> <td>Tribal Knowledge</td> <td>☐</td> <td>Rushing</td> <td>☐</td> <td>Heat Treat</td> <td>☐</td> <td></td> </tr> <tr> <td>LOA</td> <td>☐</td> <td>Product Improvement</td> <td>☐</td> <td>Wave/Twist in Tube</td> <td>☐</td> <td></td> </tr> <tr> <td>Substation</td> <td>☐</td> <td>Process Improvement</td> <td>☐</td> <td>Marks/Chatter</td> <td>☐</td> <td></td> </tr> <tr> <td>Past Expiry Date</td> <td>☐</td> <td>Manufacturing Process</td> <td>☐</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Misidentified</td> <td>☐</td> <td>Past Due</td> <td>☐</td> <td>OTHER :</td> <td>☐</td> <td></td> </tr> </tbody> </table>							Root Cause				Environment	☐	No Re-verification	☐	Pressure/Forced	☐		Design	☐	Operator	☐	Bending	☐		Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐		Equip/Tooling	☐	Supplier	☐	Cracks	☐		Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐		Material	☐	Use for Testing	☐	Cuffs	☐		Internal Transport	☐	Poor Information	☐	Crushing	☐		Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐		LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐		Substation	☐	Process Improvement	☐	Marks/Chatter	☐		Past Expiry Date	☐	Manufacturing Process	☐				Misidentified	☐	Past Due	☐	OTHER :	☐	
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ge ☐ Positioned Wrong

☐ Outside Dimensions

☐ Over/Under tolerance

☐ Part Incorrect

☐ Part Lost/Missing

☐ Part Moved

☐ Drawing

☐ Finish

☐ Misread

center ☐ Turning Sequence

Container No: 8048449

Part: D4293-1

Job No: 170389

Serial No/Batch: 8048449

Revision: _____

Inspector: _____

Date: 03/08/18

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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

DART AEROSPACE LTD		Work Order:	170389
Description: Fitting		Part Number:	D4293-1
Inspection Dwg: D4293	Rev: C	Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.305	+0.030/-0.010	.303	✓		SLIO	Very
R0.063	+/-0.010	.063	✓		Rad gauge	
0.125	+0.030/-0.010	.124	✓		SLIO	
0.88	+/-0.030	.870	✓			
0.500	+/-0.010	.496	✓			
0.82	+/-0.030	.832	✓			
0.39	+/-0.030	.395	✓			
0.088	+/-0.010	.085	✓			
0.625	+/-0.010	.635	✓			
1.730	+/-0.010	1.734	✓			
0.800	+/-0.010	.801	✓			
0.275	+/-0.010	.273	✓			
1.13	+/-0.030	1.126	✓			
3.11	+/-0.030	3.110	✓			
3.44	+/-0.030	3.437	✓			
2.450	+/-0.010	2.450	✓			
1.325	+/-0.010	1.325	✓			
0.305	+/-0.010	.305	✓			
2.84	+/-0.030	2.835	✓			
5.86	+/-0.030	5.858	✓			
6.52	+/-0.030	6.528	✓			
0.19	+/-0.030	.190	✓			
Ø0.272	+0.006/-0.001	.277	✓			
Ø0.323	+0.006/-0.001	.323	✓			
1.75	+/-0.030	1.752	✓			
R0.25	+/-0.030	.250	✓		Rad gauge	
4.875	+/-0.010	4.875	✓			
0.493	+/-0.010	.493	✓			
Ø0.201	+0.005/-0.001	.203	✓			
0.800 deep	+/-0.010	.800	✓			
CSK Ø0.320 x 100°	+/-0.010	.315x100°	✓			
0.663	+/-0.010	.663	✓			
C-bore Ø0.765	+/-0.010	.765	✓			
6.20	+/-0.030	6.200	✓			
R0.13	+/-0.030	.130	✓		Rad gauge	
1.125	+/-0.010	1.122	✓			
Ø0.381	+0.000/-0.001	.381	✓			

